

Date: Monday, 03/11/2008 8:59:49 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE RH (209)
Job Number	: 43138		
Estimate Number	: 11599		
P.O. Number	:	Part Number	: D29182
This Issue	: 03/11/2008 S.O. No. :	Drawing Number	: D2918 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	: <u>Jul 02.11.03</u>	Due Date	: 10/11/2008 Qty: <u>3</u> Um: Each
Checked & Approved By	:		
Comment	: Est: A 04.07.16 New Issue KJ/JLM est B 07.08.07 ECN930 EC verified by: JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6102011 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

6061-T6 8.25x6.5x2.5

Cut blanks: 2.500" x 8.250" x 6.50" grain along 6.50"

Material: 6061-T6/T651 (QQ-A-250/11)

(D6102-011)

Identify as D2918-2

Batch: B37601

mk 08/11/05

③

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number

Machine Step No 1 as per Folio FA440 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Machine Step No 2 as per Folio FA440 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Machine Step No 3 as per Folio FA440 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Deburr

mk 08/11/05

③

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per Dwg D2918 & attached dimension sheet

mk 08/11/05

③

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE RH (209)

Job Number: 43138

Part Number: D29182

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 08/11/05

(3)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SF 08/11/06

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FZ 08/11/07

(3)

7.0

POWDER COATING

POWDER COATING



M109152



(3X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
OF
320
8:30

mf 08/11/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FZ 08/11/10

(3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57423

Pc 08/11/10

(3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-10

DART AEROSPACE LTD	Work Order: 43138
Description: Saddle RH	Part Number: D2918-2
Inspection Dwg: D2918 Rev. A1 <i>06-11-10</i>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2918 Rev. A1 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.090	0.110		100	105	105			
B	0.175	0.205		191	193	192			
C	0.175	0.217		183	187	191			
D	R0.470	0.530		500	500	500			
E	0.740	0.760		757	760	760			
F	0.277	0.297		280	278	282			
G	3.170	3.230		3.200	3.195	3.197			
H	0.180	0.220		180	180	180			
I	1.599	1.614		1.612	1.612	1.612			
J	0.250	0.270		260	264	264			
K	4.436	4.446		4.442	4.438	4.436			
L	1.498	1.508		1.504	1.507	1.504			
M	1.278	1.288		1.282	1.281	1.288			
N	0.053	0.073		058	063	063			
O	1.103	1.113		1.112	1.110	1.111			
P	1.225	1.235		1.227	1.229	1.226			
Q	0.257	0.262		259	260	260			
R	1.990	2.010		2.005	2.004	2.003			
S	1.385	1.400		1.396	1.397	1.396			
T	0.760	0.765		766	760	760			
U	0.307	0.312		310	310	310			
V	0.615	0.635		626	628	627			
W	0.438	0.443		440	440	440			
X	0.490	0.510		502	500	502			
Y	1.745	1.755		1.750	1.750	1.750			
Z	3.495	3.505		3.500	3.500	3.500			
AA	7.990	8.010		8.006	7.999	8.000			
AB	0.023	0.043							
AC	0.173	0.193							
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: <i>mk</i>	Audited by: <i>S.P.</i>
Date: 08/11/05	Date: 08/11/06

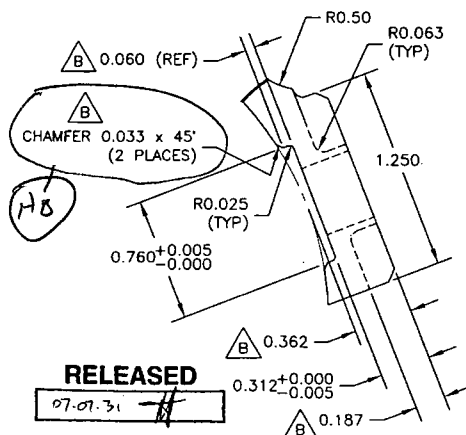
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	



NOTES:

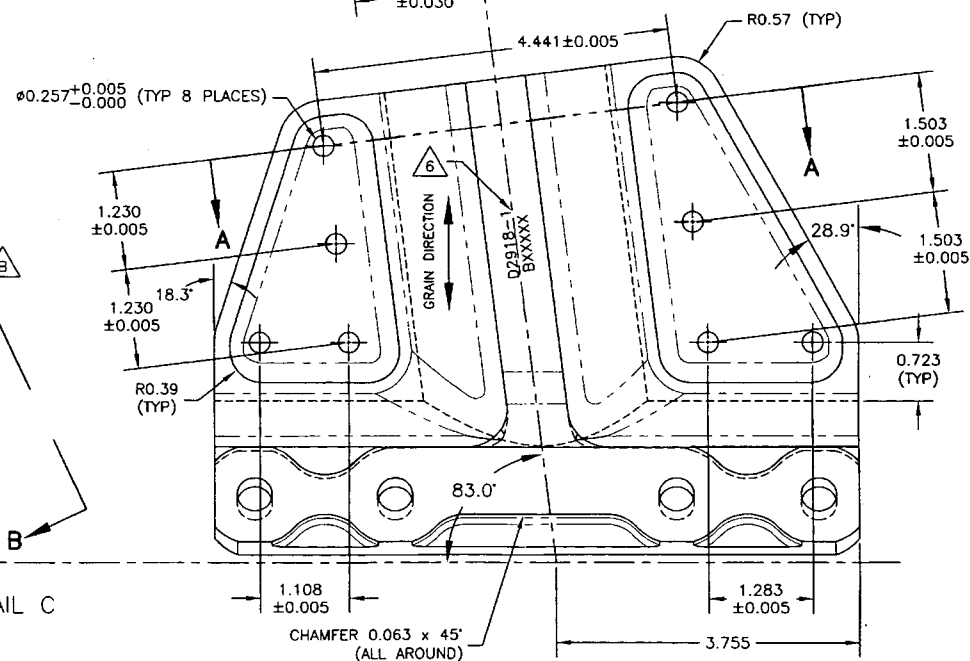
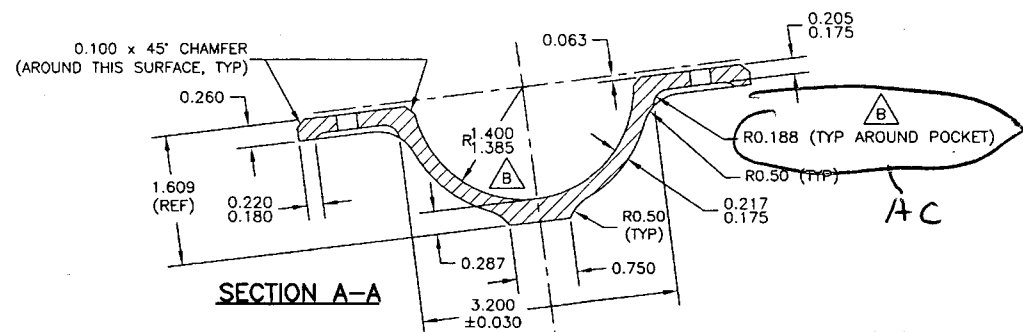
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/111
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125

DETAIL C 
SCALE 4:3



RELEASED

07.07.31



B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES	
A	04.05.31	NEW ISSUE	
DESIGN QP	DRAWN BY CB	DART	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED PH	APPROVED HH	DRAWING NO. D2918	REV. E SHEET 1 OF 2
DATE 07.02.19		TITLE SADDLE	SCALE 2:

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DART DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA

DRAWING NO.	REV. B
D2918	SHEET 1 OF 1
TITLE	SCALE
SADDLE	2:3